

Work Order ID 61637

Monday, August 30, 2010 3:47:04 PM



Page 1

Item ID: D2739

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 I Beam

Start Date: 8/30/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: *RV*

Date: *10-8-30*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2739	Rev D

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739.
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
3-Use uni-bit to open holes to finish size as per Dwg D2739.
4-Bevel Fwd end of extrusion and Deburr holes and ends.
5-Deburr

(XB)

BB 10/09/08

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

SAD
10-09-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2739 PAR #: _____ Fault Category: Skid tubes NCR: Yes No DQA: ✓ Date: 10.09.13
 Resolution: Accepted Disposition: use as is. QA: N/C Closed: ✓ Date: 10/09/13

NCR: <u>61637</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.09.07	100	ONE $\phi 0.625$ HOLE OPENED TO $\phi 0.750$ @ the 35.35" location. This hole is was next to $\phi 0.750$ ".	<u>Q</u> 10.09.07 QSI 042	Acceptable	<u>BB</u> 10/09/08	<u>DP</u> 10-9-8	<u>Q</u> 10.09.07 QSI 042	<u>✓</u> 10.09.13
		RC: LOA.						

NOTE: Date & initial all entries

Work Order ID 61637

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Item ID: D2739

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 I Beam

Start Date: 8/30/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 - BE 10/09/08

140



Packaging

Packaging

Identify as per dwg & Stock Location: L/L

0.00

Memo

0.00

8 BB 10/09/08

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/08 JF
mf
10-9-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 3:47:09 PM

Page 1

Work Order ID: 61637

Parent Item: D2739

Parent Item Name: 350 I Beam



Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: C 02.11.28 Reformat KJ
IPP Rev: D 06-03-21 As Per Rev C JLM
IPP Rev: E 07-07-28 As per Rev D JLM Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	161.0000	1	8			

Extrusion 'I Beam' thin

Location

Loc Qty

Loc Code

LG

161

47814

161

BB 10/08/31
X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

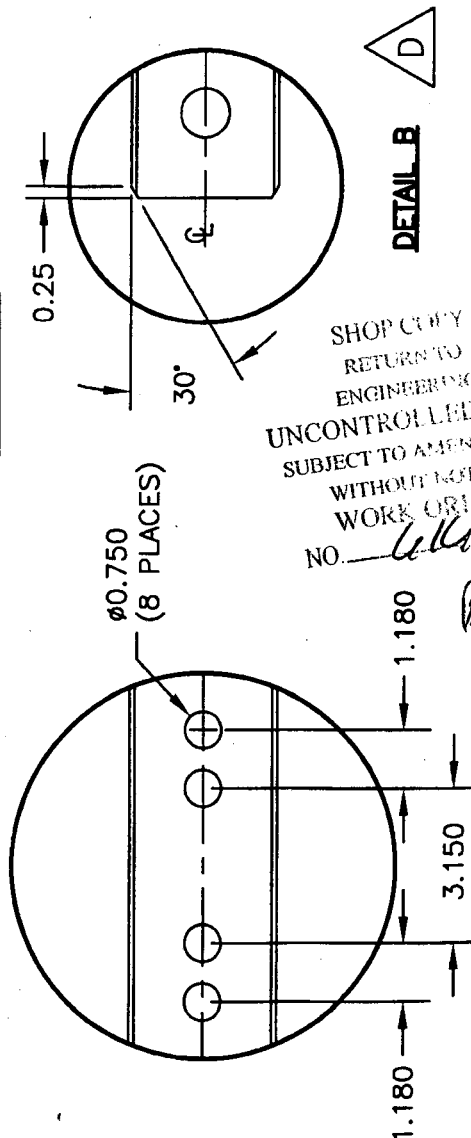
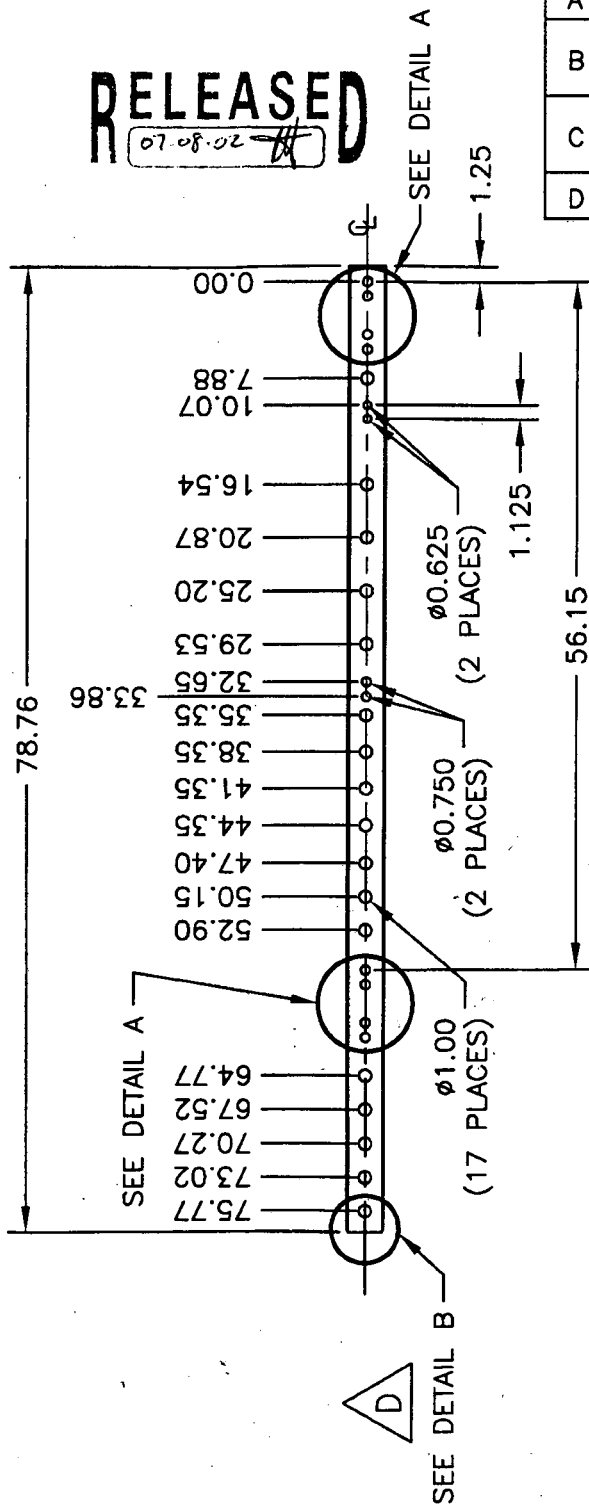
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
07-08-02

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED HA	DRAWING NO. D2739	REV. D SHEET 1 OF 1
DATE 07.05.29	TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B	



- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) PART IS SYMMETRIC ABOUT ϕ

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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